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Sold Alone

D3212-1
Job Sheet 186691



Part No: D3212-1

Job Qty: 4 ea

Part Name: Replacement Interior Window For -015 & -025



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 11/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev: A New Issue 05-11-09 JLM IPP Rev: B Water jet/ ecn798 06-05-08 EC IPP rev.C back on haas 07.04.09 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs	11/28/18	11/28/18	0.00	0.22	Waterjet - Flow		<i>sc 18/11/30</i>
110	CNC Vertical Machining	4 pcs	11/28/18	11/28/18	0.29	0.96	HAAS1-3		<i>kt 18-12-06</i>
120	QC	4 pcs	11/28/18	11/28/18	0.00	0.00	QC2 Machining-2		<i>kt 18-12-06</i>
130	QC	4 pcs	11/28/18	11/28/18	0.00	0.00	QC8 Machining-2		<i>kt 18-12-06</i>
140	Small Fab	4 pcs	11/28/18	11/28/18	0.00	0.94	Small Fab-3		<i>DEC 10 2018</i>
150	QC	4 pcs	11/28/18	11/28/18	0.00	0.00	QC5		<i>DEC 10 2018</i>
160	Packaging	4 pcs	11/28/18	11/28/18	0.00	0.00	Packaging3-1	<i>51437</i>	<i>DEC 10 2018</i>
170	QC21-SA	4 Ea	11/28/18	11/28/18	0.00	0.00	QC21		<i>DEC 10 2018</i>

Part Op 100 - 1-Cut blankas per Dwg D3212, Machine per Folio FA349 and dwg D3212

Descriptions: 140 - 1-Deburr if necessary 2-Install label as per Dwg D3212 3- polish abrasion scratches if necessary.. 4-Wrap in plastic wrap after inspection

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2728-1	Dart Logo Label Small	4 pcs (1 ea)	100-Waterjet - Flow - 1	<i>M137519</i>
MACRLICS.125	1/8" Polycast li Sheet	3.8980 sf (.9745 ea)	140-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	D2728-1	4	0	0
140-Small Fab	MACRLICS.125	4	2,220	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rew ☐ S ☐ Use ☐ Suspected Unapp ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Finishing ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____		MRB (QSI042) Approval			
Description Work Order Deviation							
DART AEROSPACE Container No: S133667 Part: D3212-1 Job No: 186691 Revision: _____ Serial No/ Batch: S133667 Inspector: _____ Exp Date: _____ Instructions: Various STC's Dart Aerospace Ltd. 1270 Appleton Street Hawkeston, ON K6A 1K7 TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐ Made Wrong ☐ e Dimensions ☐ Under tolerance ☐ ncorrect ☐ Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : _____					

DART AEROSPACE LTD		Work Order: 186691
Description: Floor Window		Part Number: D3212-1
Inspection Dwg: D3212	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.734	✓		H-G	31006
6.367	+/-0.005	6.367	✓		Kt-cs	vern.
0.625	+/-0.005	0.625	✓		"	"
Ø0.156	+0.005/-0.001	0.156	✓		"	"
R0.25	+/-0.030	0.250	✓		R-G	
8.150	+/-0.005	8.150	✓		31006	4-G
3.750	+/-0.005	3.750	✓		Kt-cs	vern
0.313	+/-0.010	0.313	✓		"	"
15.14	+/-0.030	15.140	✓		31006	4-G
12.520	+/-0.005	12.520	✓		"	"
6.260	+/-0.005	6.260	✓		"	"
1.312	+/-0.005	1.312	✓		"	"
0.313	+/-0.010	0.313	✓		"	"
3.750	+/-0.005	3.750	✓		"	"
8.150	+/-0.005	8.150	✓		"	"
8.462	+/-0.005	8.462	✓		"	"
9.09	+/-0.030	9.09	✓		"	"

Measured by: <i>KJ</i>	Audited by: <i>DAS</i> 20 9-89	Preliminary Approval:
Date: 2018-12-06	Date: 18-12-06	Date:

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	07.05.28	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	12.02.01	Dwg Rev updated	KJ	

241
35
241